

Date: Tuesday, 10/3/2006 2:48:40 PM
 User: Kim Johnston

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: N1 GEARBOX ACCESS PANEL KIT		
Job Number	: 28819-2		Part Number	: D412705017		
Estimate Number	: 12505		Drawing Number	: D3255 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 10/3/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 10/25/2006 Qty: 3 Um: Each		
Previous Run	: 28116					
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:C Removed Manufacturing 06-08-02 JLM					

Additional Product

Part Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	DC	DOCUMENT CONTROL	(3) KS 06-10-11
	Comment: Photocopy bluefile & type labels per PPPD412-705-017	CHG001	or control
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1		
	Pick Packing Kit		
3.0	D3255041	Access Panel Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)	B28124 2P L710/10	
	Access Panel Assembly		
	Batch: B28124 1P		10 7/10/03
4.0	D3255042	Access Panel Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)	B28125 2X L710/10	
	Access Panel Assembly		
	Batch: B28125 1P		10 7/10/03
5.0	AN3C3A	Bolt	
	Comment: Qty.: 30.0000 Each(s)/Unit Total: 90.0000 Each(s)		
	Bolt		
	Batch: M103668		10 7/10/03

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 28819

Part Number: D412705017

Job Number:



Seq.#: Machine Or Operation:

Description :

6.0 MS932109
Washer

(+2) Comment: Qty.: 30.0000 Each(s)/Unit Total: 90.0000 Each(s)
Washer M102382(704)

M10505 F 204

7.0 MS20427M33
Rivet

(+2) Comment: Qty.: 48.0000 Each(s)/Unit Total: 144.0000 Each(s)
Rivet M102328 -
Batch: M102328 -

M10505 F 204

8.0 MS21060L3K
Nut Plate

(+2) Comment: Qty.: 24.0000 Each(s)/Unit Total: 72.0000 Each(s)
Nut Plate M18575 154 M10505 F 574 -
Batch: M18575 154 M10505 F 574 -

M10505 F 574 -

9.0 QC4
INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

M10505 F 574 -

10.0 PACKAGING 1
PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D412-705-017
Location: A
PPP Rev: A

M10505 F 574 -

11.0 QC21
FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

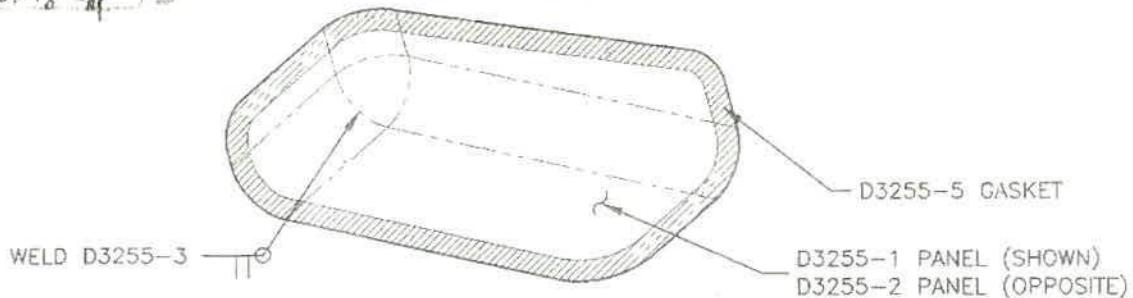
M10505 F 574 -

Job Completion

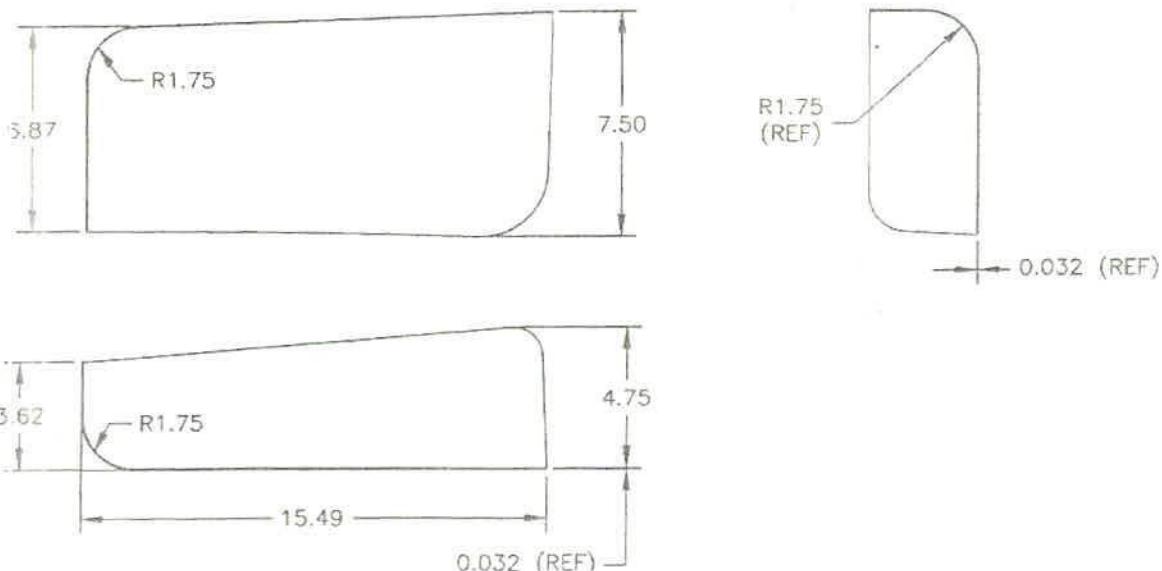
M10505 F 574 -

DART

DESIGN PF	DRAWN BY PF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>ip</i>	APPROVED <i>SH</i>	DRAWING NO. D3255	REV. B	SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6	
A	04.01.27	NEW ISSUE		
B	04.12.06	D3255-3 REDESIGN; ADDED \$0.098		

RELEASED
05.01.18 *ft*

D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

1) WELD PER DART QSI 004

2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3

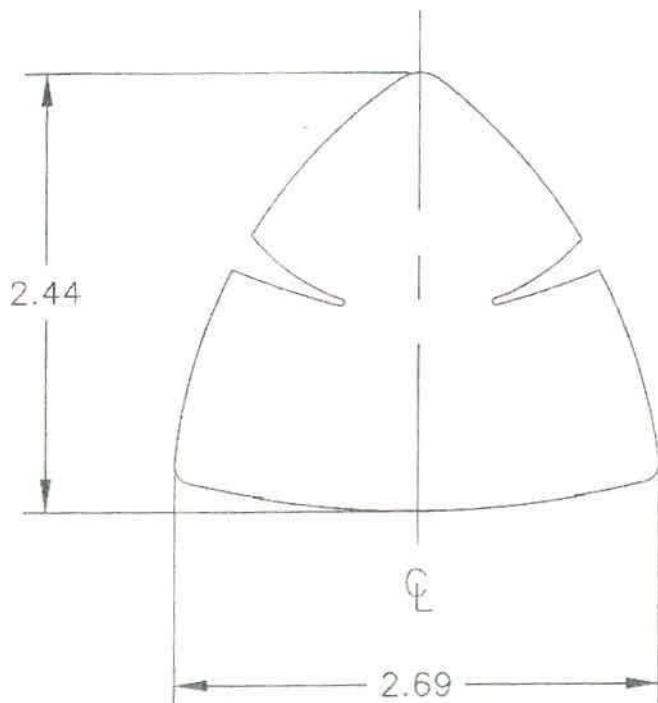
3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO. 28819

DART

DESIGN PF	DRAWN BY PF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 9P	APPROVED HF	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06	TITLE	TITLE	SCALE 1:1

RELEASED
05.01.18 ~~H~~

D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

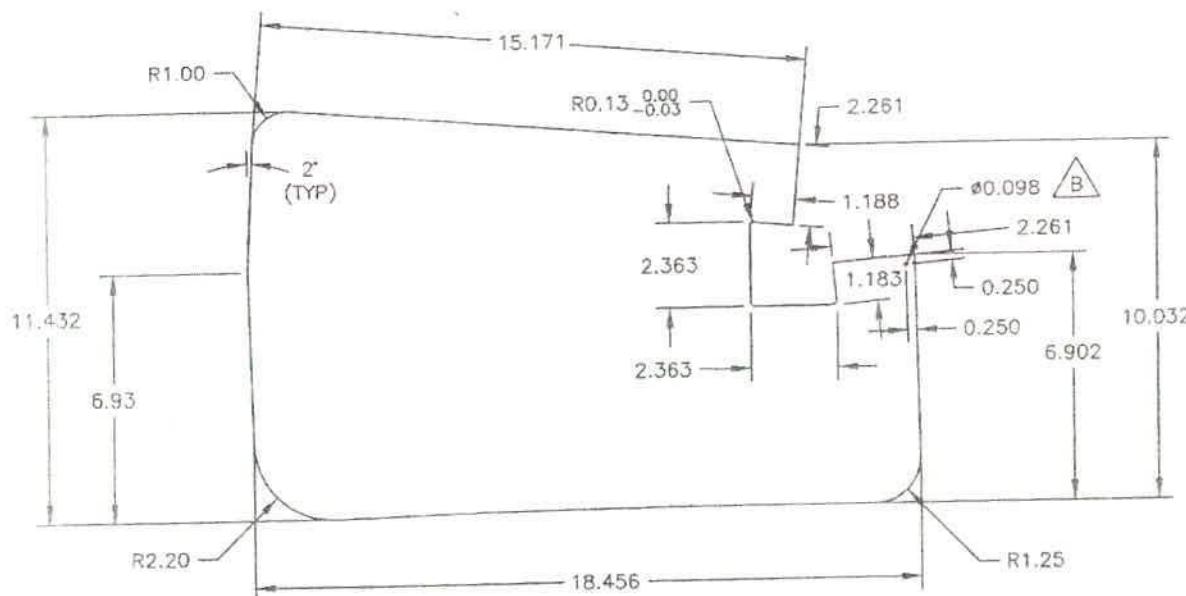
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DART

DESIGN FF	DRAWN BY FF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED IP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

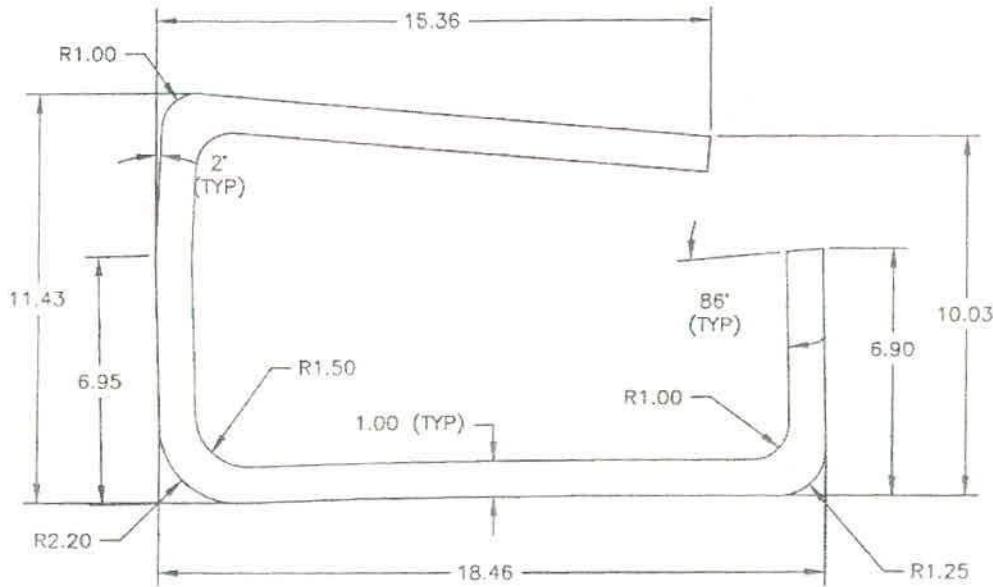
RELEASED
05-01-18D3255-1/-2 FLAT PATTERND3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART

DESIGN TT	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED TF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05.01.18 *H*D3255-5 GASKETD3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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